Type

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

: 32378 - 1 Job Number : 10832 Estimate Number

: HIA P.O. Number : 5/16/2007 This Issue

Prsht Rev. First Issue

: 31250 Previous Run

Written By

Checked & Approved By Comment

New DWG rev (mpp 2069) EC : Est. B 00.06.26

S.O. No. : N 1

Est Rev:C As per Rev C 07-03-19 JLM

: MACHINED PARTS

Part Number

Drawing Name

Drawing Number Project Number

Drawing Revision Material Due Date

: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

: D29322 D2932 REV C

· N/A : C : NIWS

: 6/6/2007

Each 16 Urn: Qty:

Additional Product

Job Number:



Seq. #: 1.0 Machine Or Operation:

D6101003

Description:

7075-T7351 2X6.25X7 875

Comment: Qty.: -

16.0000 Each(s) 1.0000 Each(s)/Unit Total:

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88 F Grain Along Long 7.88 Length

Batch No: 1331387

HAAS!

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

CONVENTIONAL MILLING MACHINE





Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet INSPECT ALL DIM TO DIM SHEET

3.0



Comment: INSPECT ALL DIM TO DIM SHEET

Wednesday, 5/16/2007 8:13:35 AM Kim Johnston

Process Sheet

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE Customer: CU-DAR001 Dart Helicopters Services

Job Number: 32378

Part Number: D29322

Job Number:

Seq. #:

5.0

Machine Or Operation:

SECOND CHECK

Description:

Comment: SECOND CHECK

5.0

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SPRAY PAINTING

7.0

SPRAY PAINTING





Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

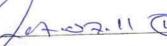
-CLEAR DELFLEET

8.0

QC14



INSPECT SPRAY PAINT





Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

10.0





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.07.12

Part Number:	D2932-2
	Page 1 of 1
	Part Number:

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

nspect dimensions highlighted on inspe			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	, 3	4	Ву	Date
Α	0.100	0.140		0.125	0.126	0126	0.126		
В	0.100	0.140		0-127	0.127	0-126	1 120		
C	0.100	0.140		0.120	0119	0.120			
D	0.210	0.230		0.225	0.222	0,223	7.250		
E	1.245	1.255		1.249	1.256	1.250	1,250		
F	1.245	1.255		1.249	1.258	1-250	2 1100		
G	2.495	2.505		2.500	7.499	2.499	0.570		
H	0.510	0.515		0.570	0.510	0.570	0.570		
1	1.572	1.582		1.576	1.576	1575	1.577		
J	2.495	2.505		2.499	2.500	2.499	2.499		
K	0.257	0.262		0.258	0.258	6.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	6.314		
M	0.235	0.240		10.240	0.240	6240	0.240		
N	0.100	0.140		0.119	0.117	0.117	0117		
0	0.540	0.560		0.548	0.549	0.550	0.548		
P	0.490	0.510		0.499	0.504	0.502	3202		
	3.715	3.725		3.717	3,7/7	3.716	0504 3.717 2.492 0.253		
Q	2.470	2.510		2.494	2,494	2.494	3.492	-	
R	0.240	0.270		0.255	0,254	0.257	0.255	-	
S	0.100	0.180		0.140	0.138	0.138	0.138		
	1.625	1.635		1.628	1.629	1.629	1.678		
U		1.372		1.368	1.367	1.367	1.367		
V	1.362	0.321		0.320	0.320	0.320	0320		
W	0.316	1.145		1.135	1.133	1.134	1.134		
X	1.125	1.585		1.574	1.573	1.573	1.573		
Y	1.565	0.198		0.88	0.188	0.188	0.188		
Z	0.176	0.130					-	-	
AA.	1							-	
AB									
AC	-	-							
AD	-	-							-
AE		-						-	
AF		-	-						
AG		-	-						
AH		cept/Rej	act						1

Ассерии	0,000	
	and	Audited by
Measured by:	- 11/2/-	Date: 01.06.26
Date:	B +106125	

BALL DESIGN	C THE SHAWN THE TAX		Revised by	Approved
Rev	Date	Change		
The second second	The second	New Issue	KURF	
1 2 2 10	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	RUKW M	
	03.21	Revised per drawing revision C		